

25

Date: Monday, 6/18/2007 7:23:37 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARMOR SHIELD
Job Number : 32914	
Estimate Number : 12369	
P.O. Number : <i>N/A</i>	Part Number : D412664203A
This Issue : 6/18/2007 S.O. No. : <i>NA</i>	Drawing Number : DSI9326
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : A
Previous Run : 31162	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/22/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature] 07.06.18</i>	
Comment : Est Rev. A New Issue 06-04-19 JLM est rev. B Per ECN 886 06.12.08 EC	

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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①

Comment: Photocopy bluefile & type labels per PPP D412-664-203A CHG004

KS 07.06.18

2.0	D412664203	Crosstube Aft High
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

KT End Crosstube

Batch: *30188*

KT 07-06-19

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Remove tube from packaging

KT 07-06-19

2-Apply Armor shield as per DSI 9326

A/R Armor Shield Batch: *M104535*

4.0	QC14	INSPECT SPRAY PAINT
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PTC

Comment: Inspect Spray Paint

207.06.20 @

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203A

Location:

PPP Rev:

Rev Q

7/6/20 59

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-06-20	1.1	Change clamps c: rubber to Rev. D Dwg D412-664-243. 2x MS21920-30 B# M101568 2x D3595-03-570 B 31948	ET	07-06-20	1	[Signature] 07-06-20	[Signature] 07-06-20	
07-06-20	4.2	QC 5	[Signature] This two only	07-06-20	1	[Signature] 07-06-20	[Signature] 07-06-20	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/20
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



①

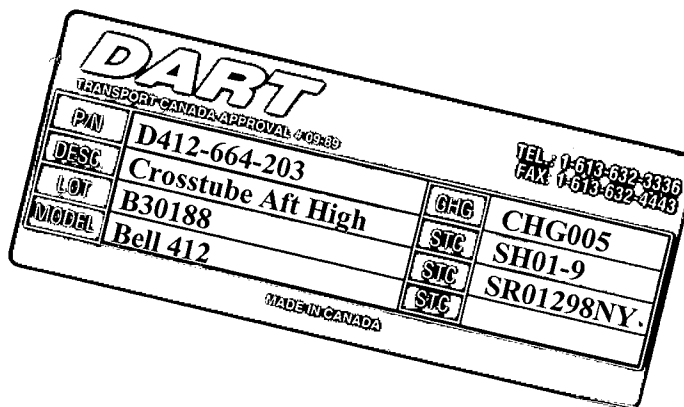
Comment: FINAL INSPECTION/W/O RELEASE

07/18/00

Job Completion



07/18/00



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED J.J.	APPROVED A	DRAWING NO. DSI 9326	REV. A SHEET 1 OF 1
DATE 06.02.14		TITLE ARMOR SHIELD	SCALE NTS
A	06.02.14	NEW ISSUE	

DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment.

INSTALLATION	CANADIAN STC	FAA STC
D205-596-101/-103/-105/-107	SH03-6	SR01742NY
D212-664-101/-201 D412-664-203	SH01-9	SR01298NY
D206-667-101/-103/-201/-203 D407-667-105/-205	SH01-5	SR01304NY
D058-676-101/-201	N/A	SR01018SE

To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. It is acceptable to apply the Armor Shield in regions shown in Figure 1 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

1.0 To apply Armor Shield

- 1) Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 2) Mask areas around supports and cuffs per Figure 1. Abrade paint finish in areas requiring protection using 320 grit sandpaper.
- 3) Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area.
- 4) Apply 3 coats of Proform PF 746 or PF 746-1 to surface (apply additional coats when surface is dry, but not fully cured)
- 5) Allow 5 hours for coating to dry.
- 6) Apply 2 coats of Imron 500s Polyurethane Enamel clear + Dupont Imron Polyurethane Enamel Activator 192S (mix 3:1). Mix 15 minutes prior to application and allow 15 minutes before applying additional coats.

2.0 Armor Shield removal/re-application

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 1) Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2) Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 3) Apply Armor Shield in accordance with Section 1.0 of these instructions.

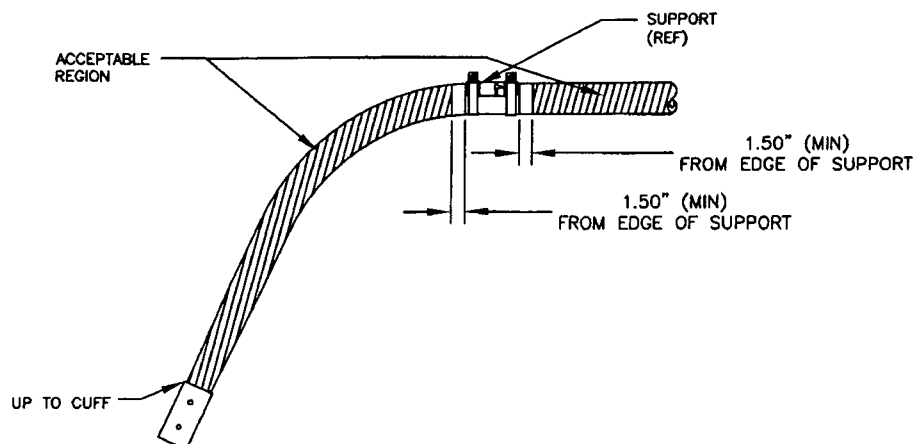


FIGURE 1 – ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32914

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 06.02.14
CERT. NO.: SH03-6/SH01-9/SH01-5
ISSUE NO.: 3/3/3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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